



Dart Aerospace Ltd.
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D3415-041
Job Sheet 200937

DAS
21
9-59

48

Part No: D3415-041

Job Qty: 40 pcs

Part Name: Nut Plate



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/19/19

Job Tracking No:

Due Date: 10/10/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP: A 05.10.03 New issue KJ/JLM IPP Rev:B Now on Waterjet 07-03-06 JLM IPP REV:C
14.04.21 DWG rev.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	40 pcs		10/10/19	0.17	1.39	Waterjet - Flow	9/30/19	JRB
110	QC 2	40 pcs		10/10/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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Container No: S218586

Part: D3415 - 041

Job No: 200937

Serial No/Batch: S218586

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/30/19

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120 QC 8	40 pcs	10/10/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	JRB 9/30/19
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	SFP 3 0 2019
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
130 Small Fab - 2 - B4B	40 pcs	10/10/19	0.00 1.50	Small Fab - 1 - B4B	DAS 40 9-89
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
				Small Fab - 8 - B4B	
140 QC 5	40 pcs	10/10/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Powdercoat - 1 White GI(A)-	40	10/10/19	0.00 0.23	Powdercoat - 1 - B4B	

B4B M193489			pcs			Powdercoat - 2 - B4B	
START 12:40 O.V.T. 760° FAKIST 1.10.			40			Powdercoat - 3 - B4B	BK 19-10-11.
160 QC 3			pcs	10/10/19	0.00 0.00	Powdercoat - 4 - B4B	
							QC 3 - 10
							QC 3 - 13
							QC 3 - 15
							QC 3 - 17
							QC 3 - 18
							QC 3 - 2
							QC 3 - 28
							QC 3 - 3
							QC 3 - 30
							QC 3 - 34
							QC 3 - 36
							QC 3 - 41
							QC 3 - 51
							QC 3 - 58
							QC 3 - 59
							QC 3 - 68
							QC 3 - 9
							QC 3 - 40
							QC 3 - 19
							QC 3 - 43
							QC 3 - 24
							QC 3 - 61
							QC 3 - 81
170 Small Fab - 3 - B4B			40	10/10/19	0.00 1.50	Small Fab - 1 - B4B	DAS 58 OCT 04 2019
							Small Fab - 2 - B4B
							Small Fab - 3 - B4B
							Small Fab - 4 - B4B
							Small Fab - 5 - B4B
							Small Fab - 6 - B4B
							Small Fab - 7 - B4B
							Small Fab - 8 - B4B
180 QC 5			40	10/10/19	0.00 0.00	QC 5 - 10	
							QC 5 - 12
							QC 5 - 17
							QC 5 - 18
							QC 5 - 19
							QC 5 - 22
							QC 5 - 24
							QC 5 - 3
							QC 5 - 43
							QC 5 - 49
							QC 5 - 51
							QC 5 - 58
							QC 5 - 68
							QC 5 - 9
							QC 5 - 50
							QC 5 - 30
							QC 5 - 40
							QC 5 - 61
							QC 5 - 81
190 Packaging 3-1 - Stock - B4B			40	10/10/19	0.00 0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B
							Packaging 3 - 3 - B4B
							Packaging 3 - 4 - F P001
							DAS 74 OCT 09 2019

	B4B	
	Packaging 3 - 5 - B4B	
	Packaging 3 - 6 - B4B	
	Packaging 3 - 7 - B4B	
	Packaging 3 - 8 - B4B	
	Packaging 3 - 9 - B4B	
	Packaging 3 - 10 - B4B	
	Packaging 3 - 11 - B4B	
	Packaging 3 - 12 - B4B	
	Packaging 3 - 13 - B4B	
	Packaging 3 - 14 - B4B	
	Packaging 3 - 15 - B4B	
	Packaging 3 - 16 - B4B	
	Packaging 3 - 17 - B4B	
	Packaging 3 - 18 - B4B	
	Packaging 3 - 19 - B4B	
	Packaging 3 - 20 - B4B	
	Packaging 3 - 21 - B4B	
	Packaging 3 - 22 - B4B	
	Packaging 3 - 23 - B4B	
	Packaging 3 - 24 - B4B	
	Packaging 3 - 25 - B4B	
	Packaging 3 - 26 - B4B	
	Packaging 3 - 27 - B4B	
	Packaging 3 - 28 - B4B	
	Packaging 3 - 29 - B4B	
	Packaging 3 - 30 - B4B	
	Packaging 3 - 31 - B4B	
	Packaging 3 - 32 - B4B	
	Packaging 3 - 33 - B4B	
	Packaging 3 - 34 - B4B	
	Packaging 3 - 35 - B4B	
	Packaging 3 - 36 - B4B	
		Plex 9/19/19 11:21 AM Dart.lajeunesse.marie

200 QC 21 - SA

40

10/10/19

0.00 0.00

QC 21 - SA - 21

21

pcs

QC 21 - SA - 70

9-85 OCT 09 2019

QC 21 - SA - 53

Part Op 110 - (QC2- Inspect parts off machine FAI/FAIB)
 Descriptions: 120 - (QC8- Inspect parts - second check)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum)
 160 - (QC3- Inspect Part Finish)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Identify as per dwg & Stock Location:_____)
 200 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.5240 sf (.0131 ea)	100-Waterjet - Flow - 1	5202447
MS20427M3-3	Rivet	80 Ea (2 ea)	170-Small Fab - 3 - B4B	5148663
MS21070L4	Inventory	40 Ea (1 ea)	170-Small Fab - 3 - B4B	705878

ST311
ST299

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	1	473	0
170-Small Fab - 3 - B4B	MS20427M3-3	80	2,353	0
	MS21070L4	40	58	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order:	220937
Description: Nut Plate		Part Number:	D3415-041
Inspection Dwg: D3415	Rev: C	Page 1 of 1	

INSPECTION SHEET

[illegible]

Measured by:	JRB	Checked by:	40 9-80	QC Inspector:	
Date:	9/30/14	Date:	SEP 30 2019	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	07.09.26	New Issue	KJ/EC/DD	
B	16.08.29	Dwg Rev updated	KJ	
C	16.09.13	Dimensions updated per Dwg Rev C	KJ	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework Scrap Use-as-is		DEPARTMENT/PROCESS Skid-tube Small Fab Finishing Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)			
Description Work Order Deviation		Disposition		Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			

Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread									
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